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- strain hardening of the annealed strip to obtain a permanent deformation between 2 and loo and the final thickness.

2. (Amended) A process according to claim 1, wherein the core alloy contains less than 0.01% Cr, Zr, Hf, V or Sc.

3. (Amended) A process according to claim 1, wherein the brazing alloy comprises 5 to 13% silicon.

4. (Amended) A process according to claim 1, wherein the homogenization time is greater than 3 hours.

5. (Amended) A process according to claim 1, wherein the strain hardening of the annealed strip is performed with a permanent deformation between 4 and 80.

6. (Amended) A process according to claim 1, wherein the strain hardening of the 5 annealed strip is performed by skin-pass type rolling.

7. (Amended) A process according to claim 1, wherein the strain hardening of the annealed strip is performed by tension levelling.

8. (Amended) A clad strip manufactured using a process according to claim 1, wherein, after shaping and brazing, said clad strip shows a perforation-free service life in a SWAAT test according to ASTM G85 standard of over 40 days.

In the Abstract:

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The invention relates to a process to manufacture a clad strip, < 1.5 mm thick, intended for the manufacture of brazed heat exchangers, comprising:

- casting of a plate made of core alloy composed as follows (o by weight):

Si < 0.8 Fe < 0.8 Cu: 0.2 - 0.9 Mn: 0.7 - 1.5 Mg < 0.4 Zn < 0.2 Ti < 0.1 other elements < 0.05 each and < 0.15 in total, the remainder aluminum,

- homogenization of said plate between 550 and 630°C for at least one hour,

- cladding on one or two sides of said blank of a brazing aluminum alloy, preferentially containing 5 to 13% silicon,

- hot rolling followed by cold rolling of the plated blank to a thickness close to the final thickness,

- recrystallization annealing of the strip between 300 and 4000C,

- strain hardening of the annealed strip to obtain a permanent deformation between 2 and 10% and the final thickness.